



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-015
Job Sheet 182461



Agusta

Part No: D6101-015

Job Qty: 10 ea

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs		9/21/18	0.00	0.00	Purchasing		<i>AT 18/09/19</i>
110	Packaging	10 pcs		9/21/18	0.00	0.00	Packaging2		<i>AT 18/09/19</i>
120	QC	10 pcs		9/21/18	0.00	0.00	QC18		<i>AT 18/09/19</i>
130	Packaging	10 pcs		9/21/18	0.00	0.00	Packaging3-2		<i>SB 18/09/20</i>
140	QC21-SA	10 Ea		9/21/18	0.00	0.00	QC21		<i>21 SEP 26 2018</i>

Part Op 100 - Issue P/O: *040834* b) 9.450" x 6.250" x 2.50" thick (+0.030 / -0.000) d) Grain direction along 9.450"
Descriptions: length

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6101

130 - LOCATION: MAT045

AUG 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015P	Aluminum Billet	10 pcs (1 ea)	100-Purchasing	<i>511622</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-015P	10	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



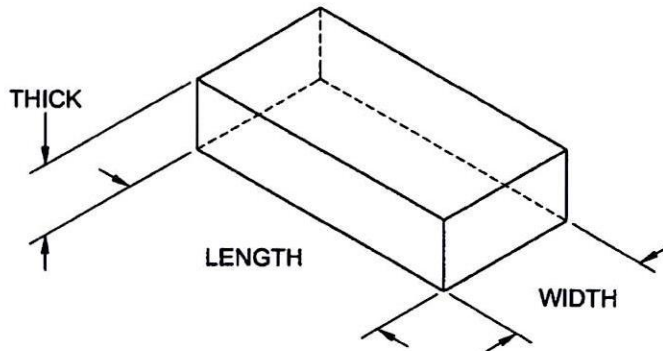
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 182461

MCJ
18-08-24

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
B D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D6101	
MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SADDLE BILLET, 7075	
DE APPR.	<i>[Signature]</i>	SCALE NTS	
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040834

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: PO040834

PO Date: 8/23/18

Due Date: 9/17/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
AUG 24 2018
Revised

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1 <i>AT</i>	182328	D6101-001P		7075-T7351 2X6X6.25 AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGTH MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	20 pcs <i>✓</i>	0 pcs <i>20x</i>	20 pcs <i>AT</i>	\$26.88/pcs <i>18/09/19</i>	\$537.60
2 <i>AT</i>	182329	D6101-013P		Saddle Billet : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A-250/12) SIZE: 10.100" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 10.100" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	10 pcs <i>✓</i>	0 pcs <i>10x</i>	10 pcs <i>AT</i>	\$73.15/pcs <i>18/09/19</i>	\$731.50
3 <i>AT</i>	182330	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	9/13/18	10 pcs <i>✓</i>	0 pcs <i>10x</i>	10 pcs <i>AT</i>	\$52.00/pcs <i>18/09/19</i>	\$520.00
4 <i>AT</i>	182320	D6104-005P		17-4 SS Roundbar 4.00"Od AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630	Firmed	-	9/6/17	10 pcs <i>✓</i>	0 pcs <i>10x</i>	10 pcs <i>18/09/06 AT</i>	\$54.20/pcs	\$542.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040834

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				SIZE: 4.00" X 5.10" LONG								
5 AT	182461	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	9/13/18	10 pcs	0 pcs 10x	10 pcs	\$52.00/pcs AT 18/04/19	\$520.00
Grand Total:												\$2,851.10

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/24/18 3:22 PM dart.baker.diane

Handwritten initials and signature.

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3704384

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-SEP-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3704384-2	

Shipment Details	Final Destination Branch - TOR
-------------------------	---------------------------------------

Order No	Line No	Item No	Description	
5239060	3	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) X 9.45 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No		Part Number	Ordered Qty	Invoice Qty
40834		YOUR ITEM NUMBER: D6101-015	10.00 PCS	10.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 122128131	Mill/Source CONSTELLUM ROLLED PRODUCTS	Heat Number 	Mech Id	PCS 10	Width (IN)	Length (IN)	Shipped Qty(LBS) 152.7121
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We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned

Date Printed: 18-SEP-2018 03:39:01 PM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

for credit.			
Reviewed by Authorized Castle Metals Representative:		Date:	Name:

SEP 18 2018

SUE KALOUS





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

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A M CASTLE & CO.
14001 ORANGE AVE
PARAMOUNT CA
90723
US

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A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE		110679005		4776		INCLUSION		Serial:20180720-0110679005		Pg 1of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 465187						Constellium ORDER NO. 243922					
ALLOY 7075		CLAD		TEMPER T7351		GAUGE 2.50000 in 63.50 mm		WIDTH 48.50000 in 1,232 mm		LENGTH 144.50000 in 3,670 mm	
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS 4078J											
PART NUMBER 752241				B/L NUMBER 103264				DATE SHIPPED 07/20/2018			
WT. SHIPPED 7120.000 LB				NO. OF PIECES 000004				GOVT. CONTRACT NO.			
										CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA	
										 Dave Dunbarger - Laboratory Manager	

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

ASTM B694 REV 13 2013 100% SONIC W/ 0.12" DEADZONE Class A
AMS QQ-A-250/12A
AMS-STD-2154C 2017 TYPE1 CLASS A 100% SONIC MINUS DEADZONE
ASTM B209-14
BSS-7055B 2013 CLASS A 100% SONIC TESTED MINUS DEADZONE
CMMP025 REV V
CST1006 REV E 2011 CLASS A 100% SONIC MINUS DEADZONE
DPS 4.713 REV AK 2012 CLASS A 100% SONIC MINUS DEADZONE
GAMPS 9101 REV B 2006 CLASS A 100% SONIC MINUS DEADZONE
MMS 159T
PS 21211P 2010 CLASS A 100% SONIC MINUS DEADZONE

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001828110	1,780.000	807.394	9420913	01		
1001828110	1,780.000	807.394	9420913	02		
1001828111	1,780.000	807.394	9420913	03		
1001828111	1,780.000	807.394	9420913	04		

Lot: 9420913 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	72.6	74.4	61.0	63.8	11.5	11.5	





Constellium



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
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A M CASTLE & CO.
14001 ORANGE AVE.
PARAMOUNT CA
90723
US

S
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A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE		110679005		4776		INCLUSION		Serial:20180720-0110679005		Pg 2of2																												
CUSTOMER PURCHASE ORDER NO. & ITEM 465187						Constellium ORDER NO. 243922		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager																														
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Tensile - Room Temperature (SI) <table border="1" style="width:100%; border-collapse: collapse; margin-top: 5px;"> <thead> <tr> <th colspan="2"></th> <th colspan="2">Ultimate (N/MM2)</th> <th colspan="2">Yield (N/MM2)</th> <th colspan="2">Elongation (%)</th> <th>Report</th> </tr> <tr> <th>Direction</th> <th>Tests</th> <th>Min</th> <th>Max</th> <th>Min</th> <th>Max</th> <th>Min</th> <th>Max</th> <th></th> </tr> </thead> <tbody> <tr> <td>LT</td> <td>02</td> <td>501</td> <td>513</td> <td>421</td> <td>440</td> <td>11.5</td> <td>11.5</td> <td></td> </tr> </tbody> </table>														Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report	Direction	Tests	Min	Max	Min	Max	Min	Max		LT	02	501	513	421	440	11.5	11.5	
		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report																														
Direction	Tests	Min	Max	Min	Max	Min	Max																															
LT	02	501	513	421	440	11.5	11.5																															
Conductivity % IACS MIN 39.3 MAX 39.4 % MS/M MIN 22.8 MAX 22.9																																						
Chemistry (Actual) <table border="1" style="width:100%; border-collapse: collapse; margin-top: 5px;"> <thead> <tr> <th></th> <th>SI</th> <th>FE</th> <th>CU</th> <th>MN</th> <th>MG</th> <th>CR</th> <th>ZN</th> <th>TI</th> <th>ZR</th> </tr> </thead> <tbody> <tr> <td>Core</td> <td>0.08</td> <td>0.18</td> <td>1.41</td> <td>0.06</td> <td>2.66</td> <td>0.21</td> <td>5.65</td> <td>0.03</td> <td>0.00</td> </tr> </tbody> </table>													SI	FE	CU	MN	MG	CR	ZN	TI	ZR	Core	0.08	0.18	1.41	0.06	2.66	0.21	5.65	0.03	0.00							
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR																													
Core	0.08	0.18	1.41	0.06	2.66	0.21	5.65	0.03	0.00																													
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																																						
All material contained in this lot was cast and manufactured in the USA																																						
QUALITY TEXTS: AMC CA-15413B R 6																																						
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557 DUNS Number: 090570149; CAGE Code: 1YWLG Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"																																						
P-860-155D REVISED: 01 2018																																						

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-015
DATE: 18/09/14

PO / BATCH NO.: P0040834/5111639

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 10
QUANTITY INSPECTED: 10
QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.500"
THICKNESS RECEIVED: 2.500"
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL PER M-DRAWING	Y	N	AMS QQ-A-250/12
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT REF # TO LINK CERT	Y	N	HT: 9420913
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u>	SIGNED OFF BY: _____
DATE: <u>18/09/14</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in